

Work Order ID 54866

January 4, 2010 10:44:58 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date: 10-1-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827 PD

A/R S.S. Rod Batch: M109213

7- grind weld flush PD

8- deburr if necessary PD

SAD 10-01-27

PD 001.29

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/02/01

/ Cpl 10/04/01



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

=> S 10/02/01

(46)



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00

S.A. 1

(2)



Packaging

Memo

0.00

Packaging

10-02-01

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January 4, 2010 10:44:58 AM



Page 3

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Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/02 *[Signature]*

mf

10-2-2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 4, 2010 10:45:02 AM

Work Order ID: 54866



Parent Item: D3827-041



Parent Item Name: Rib Assembly (Inboard)


Start Date: 05/01/2010

Required Date: 11/01/2010

Comments: IPP RevA: revise process 0.9.11.11 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	42.0000	18.0000			

M304TS0.750W.065

Purchased

No

100

f

314.4400

50.5263



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	42	
53442	6	
54072	36	

B 55093 -> (15) PD 10.01.29

(3) PD 10.01.29

SAD 10-01-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	314.4399742	
113082	0.00419	
113245	314.435784	
Main Warehouse		
WA	0.0000047	
112398	0.0000047	

~~M113683~~

M113683

—————> 50.5283

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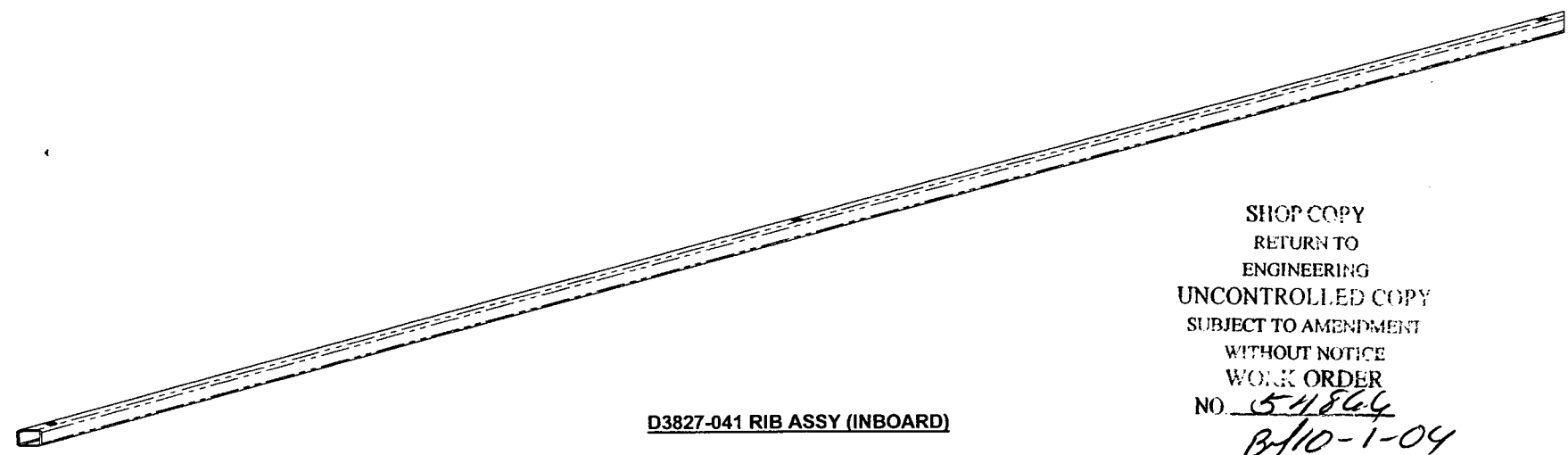
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54864
B-110-1-04

RELEASED
08/11/18

NOTES:
MATERIAL: N/A
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3827	REV. A
TITLE RIB ASSY (INBOARD)	SCALE NTS
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8 7 6 5 4 3 2 1

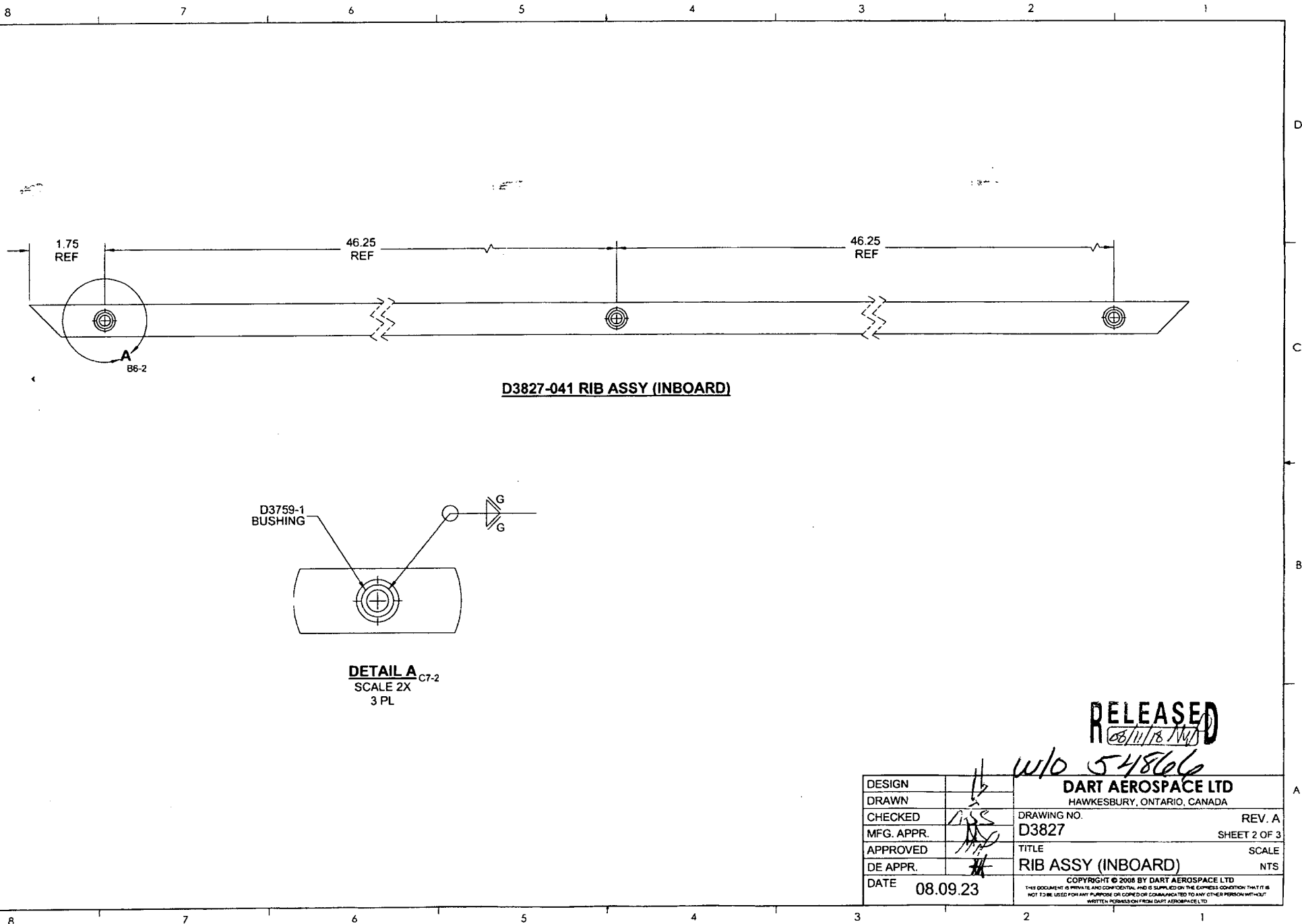
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RELEASED
08/11/18

W/0 54866

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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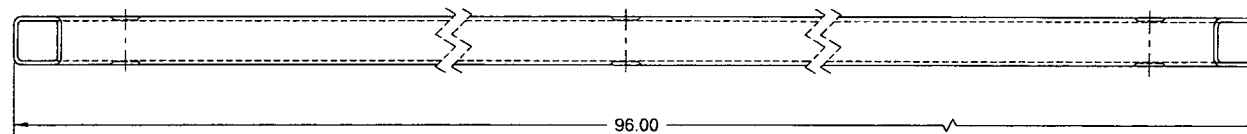
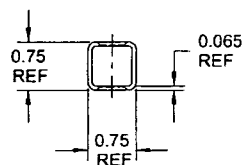
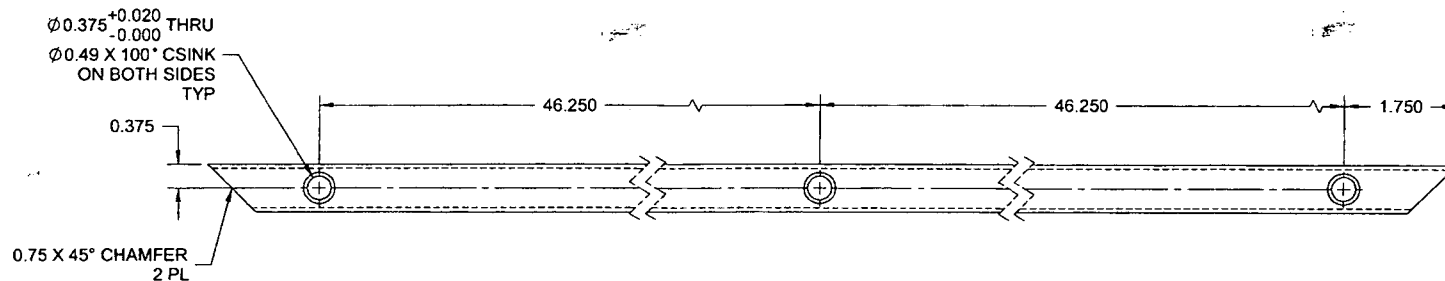
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D3827-1 RIB

RELEASED
08/11/14

WLO 54866

NOTES:
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065

FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 4.55 lbs

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